

Date: Monday, 2/19/2007 8:07:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 30752		Part Number	: D353539 Rev A	
Estimate Number	: 12729		Drawing Number	: D3535 UNDER REVIEW PH 07-02-19	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/19/2007 S.O. No. : N/A		Drawing Revision	: U/R	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/26/2007 Qty: 12 Um: Each	
Previous Run	: N/A				
Written By					
Checked & Approved By					
Comment	: Est Rev:A New Issue 07-02-15 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S20GA	304/316 .040 Sheet
Comment: Qty.: 0.9986 sf(s)/Unit Total : 11.9826 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: M161873		
SAO 07/02/25		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: A Prog Rev: A		
SAO 07/02/25		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
SAO 07/02/25 12		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
SC 07-02-25 12		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 Form Joggle on brake using Jig DT8158 as per Dwg D3535		
SB MF 07-03-06 12		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/31/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 30752

Part Number: D353539

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/03/07 (12)

7.0 POWDER COATING

POWDER COATING



M 101601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

MS | M-L 07-03-07 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

a.m 07/03/07 (12)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FIP

MS 07-03-08 (12)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

MS 07/03/08 (12)

Job Completion



U 07-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

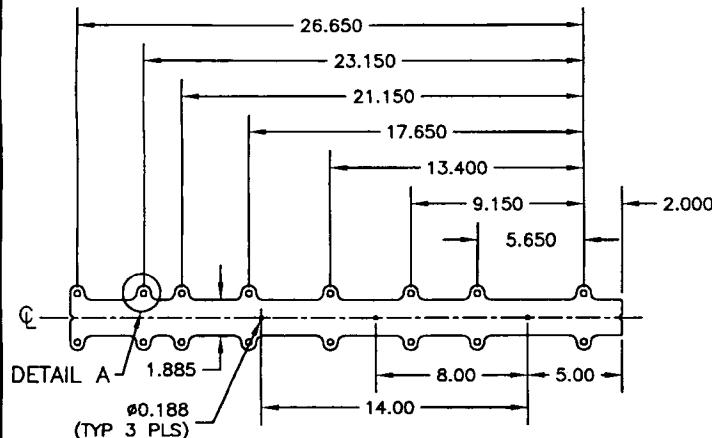
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

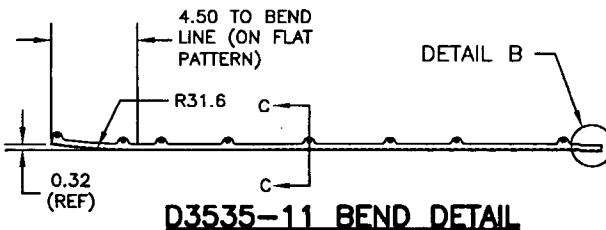
NOTE: Date & initial all entries

DART

07.02.12
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D3535-11F FLAT PATTERN

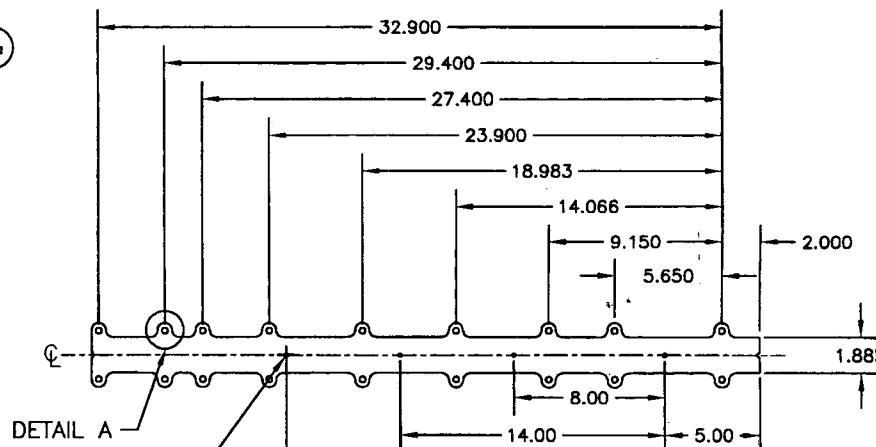


D3535-11 BEND DETAIL

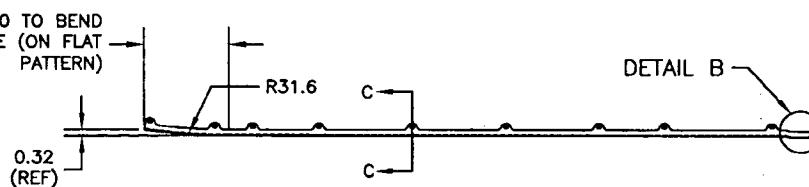
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NO. 20152

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

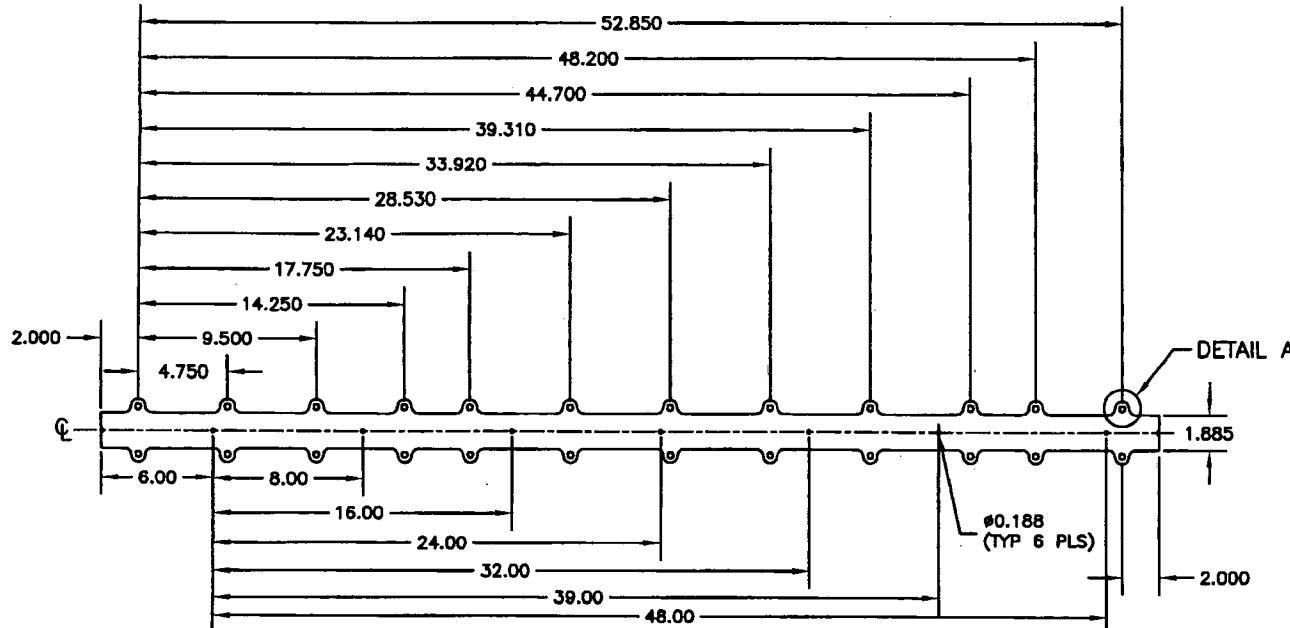
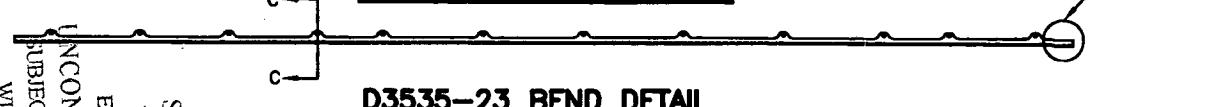
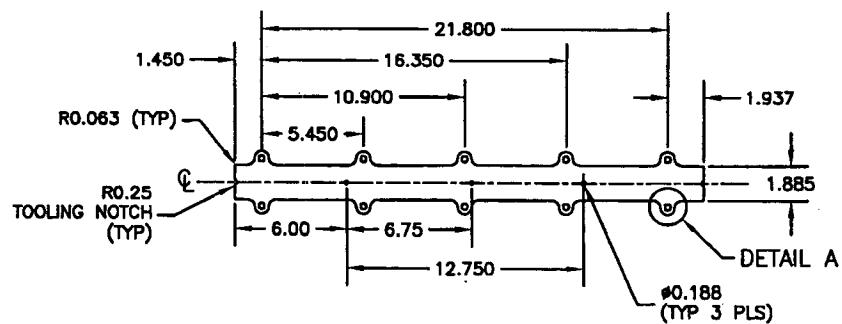
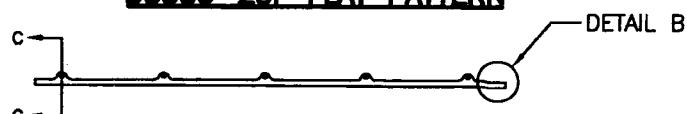
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CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
<i>PH</i>	<i>AK</i>	WEARSHOE	1:10
DATE		TITLE	SCALE
06.10.25		NEW ISSUE	
A	06.10.25		

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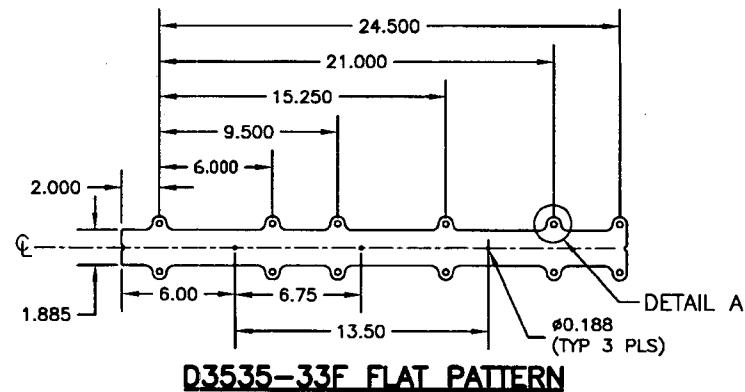
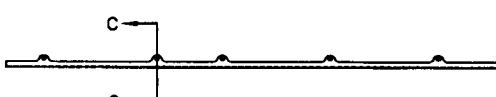
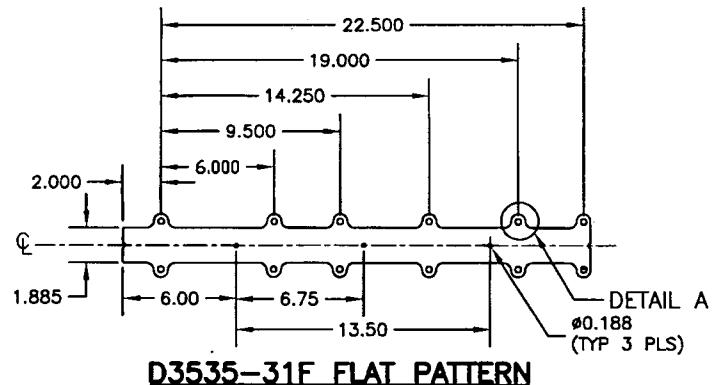
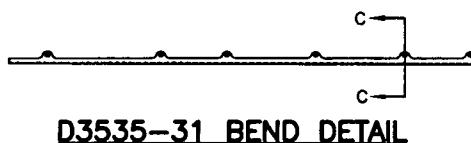
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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07.02.12 *ft***D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL**

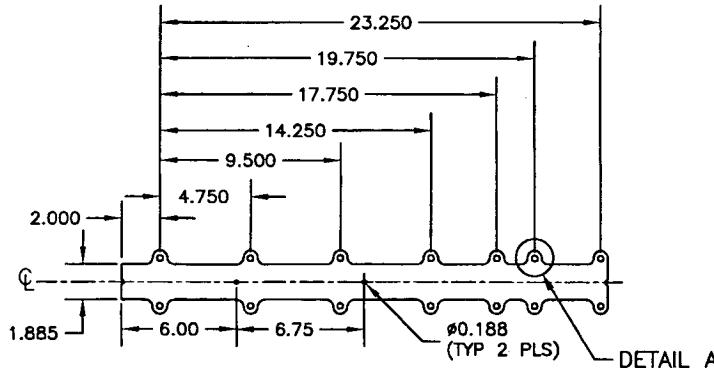
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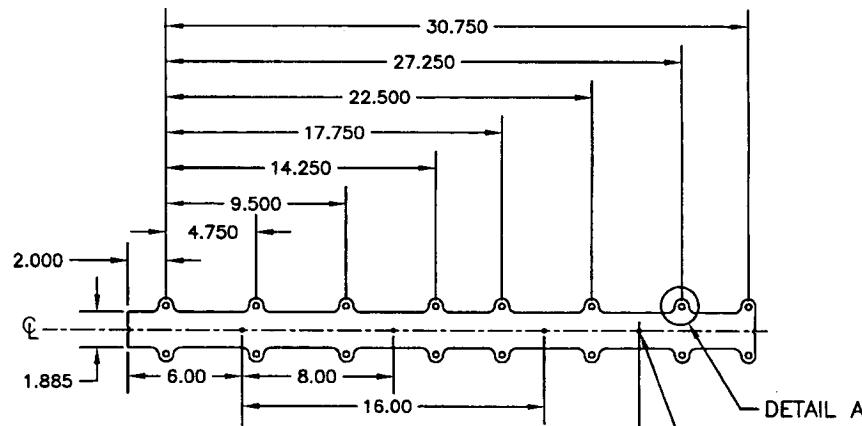
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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DART67-0212 *CH***D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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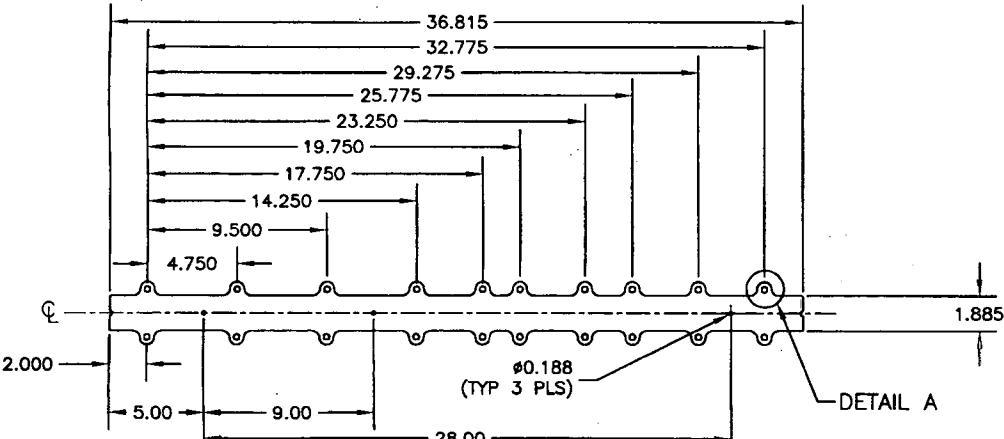
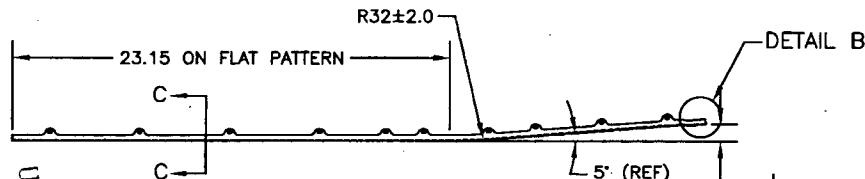
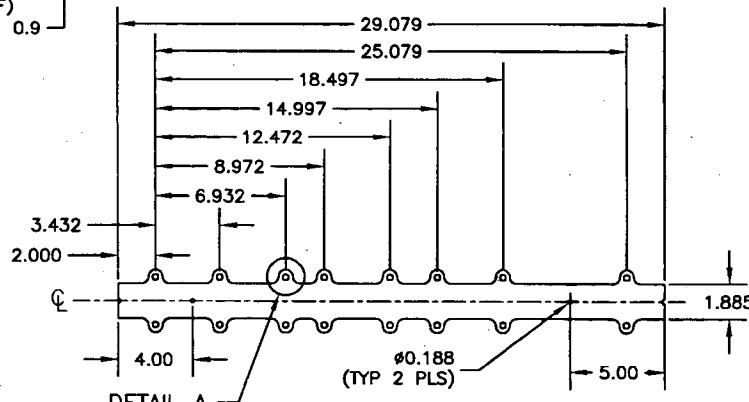
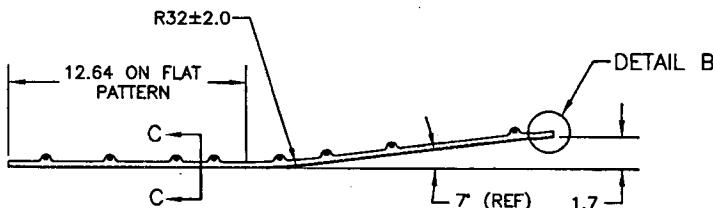
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK, REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \mathbb{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

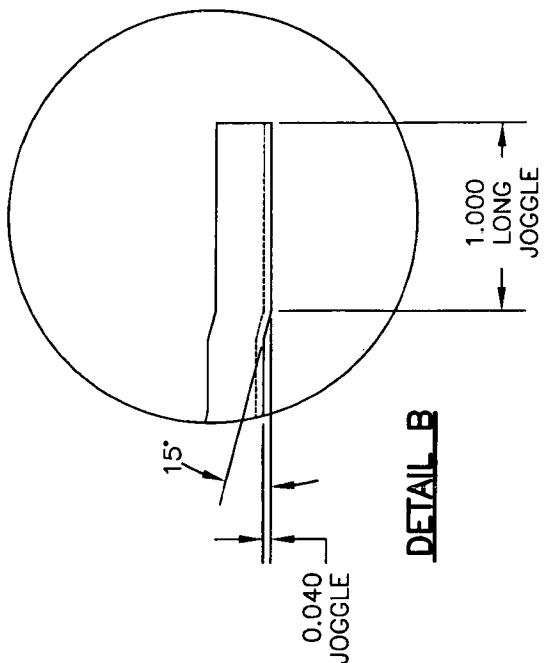
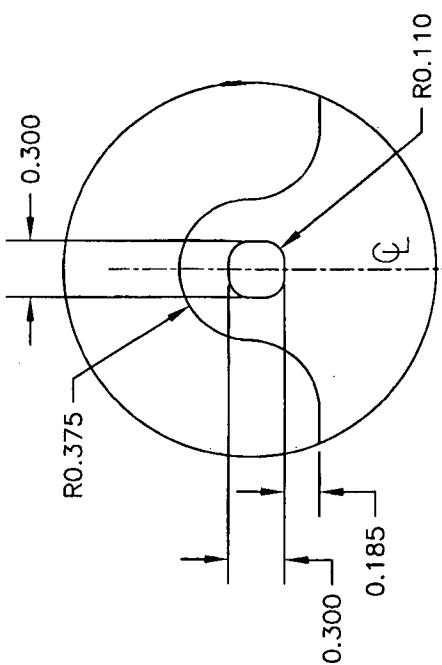
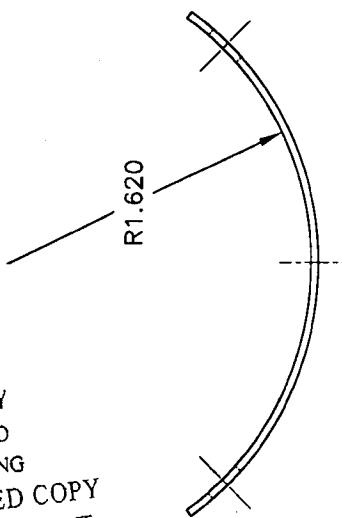
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DATE 06.10.25		TITLE WEARSHOE	SCALE 1:1

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**DETAIL B****DETAIL A****SECTION C-C**

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DART AEROSPACE LTD	Work Order:	30752
Description:	Part Number:	D8535-39
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.750	± 0.010	4.744	✓		Very	
9.500	± 0.010	9.500	✓		Very	
14.250	± 0.010	14.250	✓		M-T	
17.750	± 0.010	17.750	✓		M-T	
19.250	± 0.010	19.790	✓		M-T	
23.250	± 0.010	23.250	✓		M-T	
25.775	± 0.010	25.775	✓		M-T	
29.275	± 0.010	29.275	✓		M-T	
32.775	± 0.010	32.775	✓		M-T	
36.815	± 0.010	36.806	✓		M-T / Vern	
2.000	± 0.010	2.000	✓		Vertical Very	
5.00	± 0.030	5.000	✓		Vertical Very	
9.00	± 0.030	9.000	✓		Vertical Very	
28.06	± 0.030	28.06	✓		M-T	
1.885	± 0.010	1.888	✓		Very	
$\varnothing 0.188$	$+0.002/-0.001$	0.191	✓		Very	
0.300	± 0.010	0.297	✓		Very	
0.300	± 0.010	0.295	✓		Very	
0.038	± 0.010	0.035	✓		Very	

Measured by: JAH
Date: 07/02/25

Audited by:	
Date:	07.02.25

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New issue	KJ/JLM	